

Date: Thursday, 7/13/2006 4:01:53 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY  
 Job Number : 27913A  
 Estimate Number : 10023  
 P.O. Number : N/A Part Number : D205634041  
 This Issue : 7/13/2006 S.O. No. : N/A Drawing Number : D2580 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C  
 Previous Run : 27916A Material : N/A  
 Due Date : 8/30/2006 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 06.07.13  
 Comment : Est Rev:N 02.06.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 Est Rev. O 06.02.28 Added paperwork EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25001190 Ext'n -1' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number Description Batch

1 D2500-1-190 Skid Tube Extrusion B24669 06-07-20

2.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

N/A.

3.0 D2596 205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2596 205 Web B21655 Pm 06-07-21 (1)

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage IT 06-07-20

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends IT 06-07-20

3-Drill pilot holes using drill jig DT 8149 IT 06-07-20

4-Acid etch and Alodine tube per QSI 005 4.1 IT 06-07-20

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                 |                          |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                 |                          |
|      |      |                    |  |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                       |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action     |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 27913A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M101193

Sikaflex expire date: 06-11-01

Start Time: 8:30

Fin Time: 7:30

DP 06-07-21

Pm 06-07-21 ①

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

Pm 06-07-27 ①

2-Cut tubes as per Dwg. D2580

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

RT 06-07-31

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BF 06-08-02

8.0

D25763

Step (Machining Detail)



Comment: Qty 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2576-3

Step

B23060

BF 06-08-02

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                 |                          |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
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|      |      |                    |  |    |      |     |                                 |                          |
|      |      |                    |  |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 27913A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch              |
|-----|-------------|-------------|--------------------|
| 20  | D2579       | Spacers     | B27167 BE 06-08-02 |

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579 side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Inspect weld and Counterbore work to Step 20

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                 |                          |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                 |                          |
|      |      |                    |  |    |      |     |                                 |                          |

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|      |      |                                  | Initial<br>Design Mgr | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 27913A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/08/16 D

14.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 1   | D2577-1     | Wearplate   | B26350 |

15.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 1   | D2577-3     | Wearplate   | B26058 |

16.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 1   | D2577-5     | Wearplate   | B24878 |

17.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number   | Description | Batch  |
|-----|---------------|-------------|--------|
| 44  | ALS7-1032-130 | Inserts     | M19393 |

SC 06/08/16

18.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 44  | AN960JD10L  | Washer      | M100233 |

DL 06/08/16

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                 |                          |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                 |                          |
|      |      |                    |  |    |      |     |                                 |                          |

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|      |      |                                  | Initial<br>Design Mgr | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 27913A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 44  | AN3-4A      | Bolt        | M101697 |

20.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

| Qty | Part Number         | Description               | Batch   |
|-----|---------------------|---------------------------|---------|
| 16  | D2594- <del>B</del> | <del>O-RING</del><br>plug | M 25593 |

SC 06/08/16  
DL

21.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

| Qty | Part Number         | Description            | Batch   |
|-----|---------------------|------------------------|---------|
| 16  | D2594- <del>B</del> | <del>Plug</del> O-RING | M 24104 |

SC 06/08/16  
DL

22.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B 26351

23.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M15205

24.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M100233

PL 06/08/16 @

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                 |                          |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                 |                          |
|      |      |                    |  |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                       |                                  |                |                           |                        |                          |
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|      |      |                                  | Initial<br>Design Mgr | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/27  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 7/13/2006 4:01:54 PM  
User: Kim Johnston

## Process Sheet

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 27913A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date: 02/07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 02/07

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M101607

Batch:

FC 06.08.21

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:           

PPP Rev:           

28.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W 06.08.23

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                 |                          |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                 |                          |
|      |      |                    |  |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                       |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action     |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |
|      |      |                                  |                       |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



|                               |                                |                                                   |                        |
|-------------------------------|--------------------------------|---------------------------------------------------|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2580                              | REV. C<br>SHEET 1 OF 2 |
| DATE<br>98.08.26              |                                | TITLE<br>205 SKIDTUBE ASSEMBLY                    | SCALE<br>NTS           |
| A                             | 96.09.16                       | NEW ISSUE                                         |                        |
| B                             | 96.12.02                       | AS MANUFACTURED                                   |                        |
| C                             | 98.08.26                       | REDRAWN, INCLUDED DEO 9094/9097                   |                        |

RELEASED  
98/09/17 DS

| QTY | Part Number                                                               | Description       |
|-----|---------------------------------------------------------------------------|-------------------|
| X   | D2580-041                                                                 | SKIDTUBE ASSEMBLY |
| *   | D2500-1                                                                   | EXTRUSION         |
| 1   | D2596                                                                     | 205 WEB           |
| 1   | D2575                                                                     | AFT CAP           |
| 1   | D2576 - 3                                                                 | STEP              |
| 20  | D2579                                                                     | CROSS BOLT SPACER |
| 16  | D2594-1                                                                   | PLUG              |
| 16  | D2594-3                                                                   | O-RING            |
| 1   | D2577-1                                                                   | WEARSHOE          |
| 1   | D2577-3                                                                   | WEARSHOE          |
| 1   | D2577-5                                                                   | WEARSHOE          |
| 44  | ALS7-1032-130<br>or AKS7-1032-130<br>or AKS4-1032-130<br>or ALS4-1032-130 | INSERT            |
| 46  | AN3-4A                                                                    | BOLT              |
| 46  | AN960JD10L                                                                | WASHER            |

# 00.08.28  
UP 00.08.28

EFFECTIVE DEOS  
98/12/14  
DEO 9124  
DED 9183

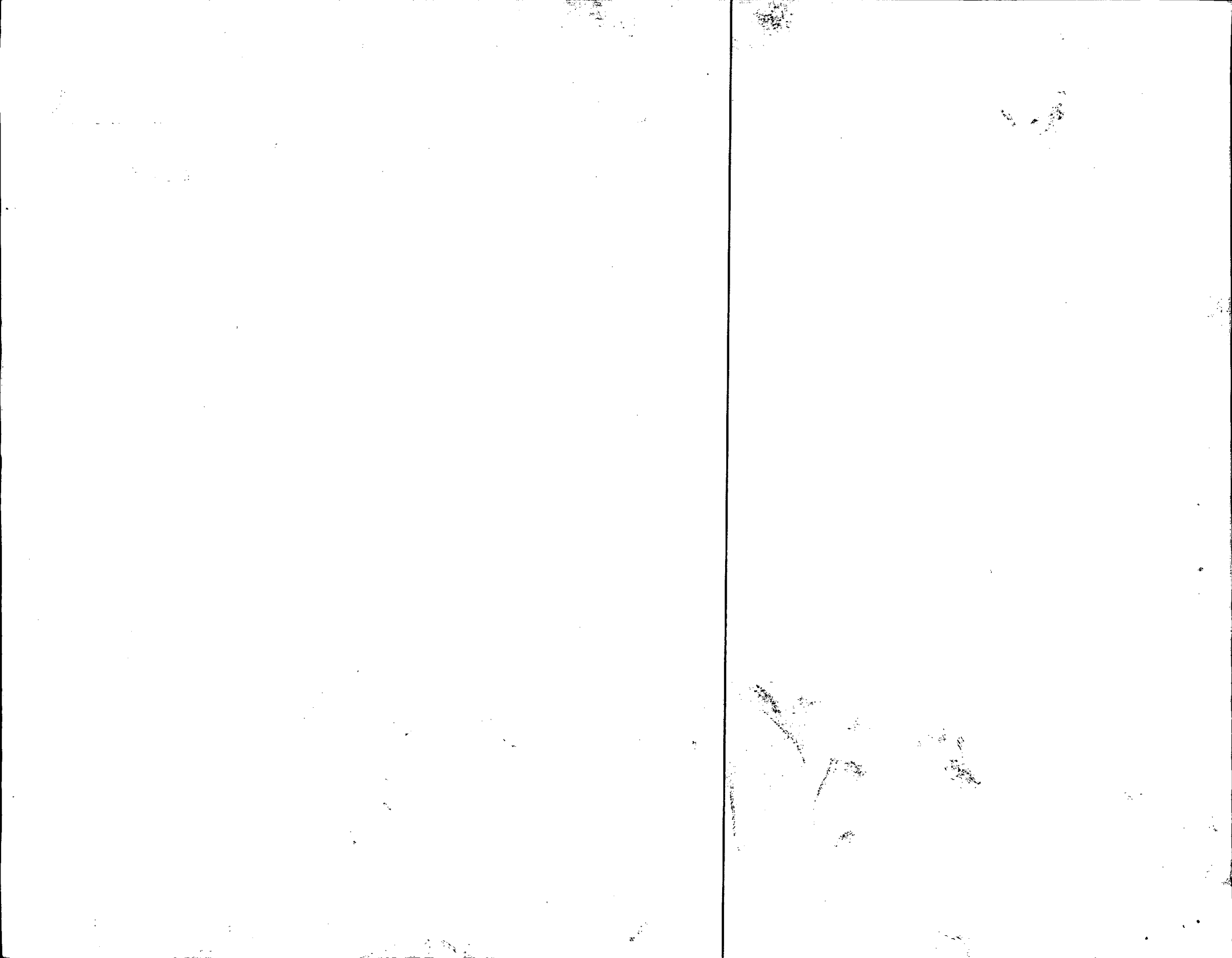
#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES \*
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27913A



**DETAIL B**  
**SCALE 5:24**

D2576-3 UG 00-08-28  
UG 00-08-28

GRIND FLUSH (4 PLACES)

GRIND FLUSH

STEP

GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576

1/8"

DRILL PRIOR TO D2575 CAP  
 INSTALLATION (2 PLACES)

SEAL WITH  
 SIKAFLEX-241

AN3-4A BOLT (1)  
 AN960JD10L WASHER (1)  
 (2 PLACES)

D2575 CAP

0.40

D2579 SPACER

WEB (REF)

-130 (REF)

14 PLACES

AFTER PERFORM

1. CHA
2. INS
3. WEI
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO  $\phi 0.437$  X 1.00 DEEP

37.50  
DISTANCE TO AFT END  
OF D2596 WEB  
3 7  
1.750 1.750  
REFER TO DETAIL A  
8.750  
17.375  
26.000  
34.188  
57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH  
38.0  
91.500  
190.0  
(D2500-1)  
#0.508 (TYP.)  
(40 PLACES)  
REFER TO DETAIL A

Diagram illustrating a horizontal curve with two circular arcs. The first arc has a radius of 13.4 and a central angle of 4 degrees. The second arc has a radius of 32.0 and a central angle of 4 degrees. The distance between the hole and the tangent point for the first arc is 1.0. The distance between the hole and the tangent point for the second arc is 1.0. The total length of the curve is 20.0. The diagram also shows a 1.4 offset from the start of the curve and a 11 offset from the end of the curve.

0.5

1.5

1.5

D

P

P

P

P

P

P

P

P

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

1.5

1.5

1.5

1.5

REFER TO DETAIL C

D2577-3

D2577-5

D2577-1

8

AN3-4A BOLT (1)  
AN96QJ10L WASHER (1)  
(44 PLACES)

DESIGN  
*[Signature]*

DRAWN BY  
*[Signature]*

DART

RELEASE  
98/09/17 DS

|                       |                                |                                                            |
|-----------------------|--------------------------------|------------------------------------------------------------|
| DESIGN<br><i>DAB</i>  | DRAWN BY<br><i>CP</i>          | <b>DART</b> DART AEROSPACE LTD<br>MARKHAM, ONTARIO, CANADA |
| CHECKED<br><i>DAB</i> | APPROVED<br><i>AS</i>          |                                                            |
| DATE<br>98.08.26      | DRAWING NO.<br>D2580           | REV. C<br>SHEET 2 OF 2                                     |
|                       | TITLE<br>205 SKIDTUBE ASSEMBLY | SCALE<br>1:24                                              |

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